

Date: Wednesday, 3/8/2006 10:38:45 AM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	HEAT OUTLET DEFLECTOR
Job Number :	26128		
Estimate Number :	12156		
P.O. Number :	N/A	Part Number :	D34725
This Issue :	3/8/2006	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3472 REV.A
First Issue :	N/A	Project Number :	N/A
Previous Run :	N/A	Drawing Revision :	A
	Type :	Material :	N/A
	PURCHASED PARTS	Due Date :	3/31/2006
Written By :	<i>SEE COMMENT BELOW</i>		Qty: 20 Um: Each
Checked & Approved By :	<i>06.03.08</i>		
Comment :	est rev. A 06.02.02 new issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	OUTSIDE SERVICE	OUTSIDE SERVICES
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**Comment:** Sub-Contracting OUTSIDE SERVICES

Issue P/O: 00000768

Email or Ship DXF file to vendor

Make as per Dwg D3472 flat pattern D3472-5F

Material release note required

2.0	D34725 F	FLAT DOUBLER
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
 FLAT DOUBLER

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 1- Deburr

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06-03-28	4.0	There were 21 parts reviewed. Took 1 Per Inspection template. DT 8867, Add DT # to step 4.					 06-03-28	
06-03-28	5.1	Buff mat'l smooth: ensure no marks or scratches as per QSI 018	SAD	06-03-29	20		 06-03-29	
06-03-28	5.2	Acetone Alodine AS per QSI 005 4.1	SAD	06-03-29	20			
		Add Above to I.P.P. permanent change						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: Date: 06/03/29
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 10:38:45 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HEAT OUTLET DEFLECTOR

Job Number: 26128

Part Number: D34725

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

0603-29

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

0603-29 (20)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/03/29 (20)

Job Completion



U 06-03-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

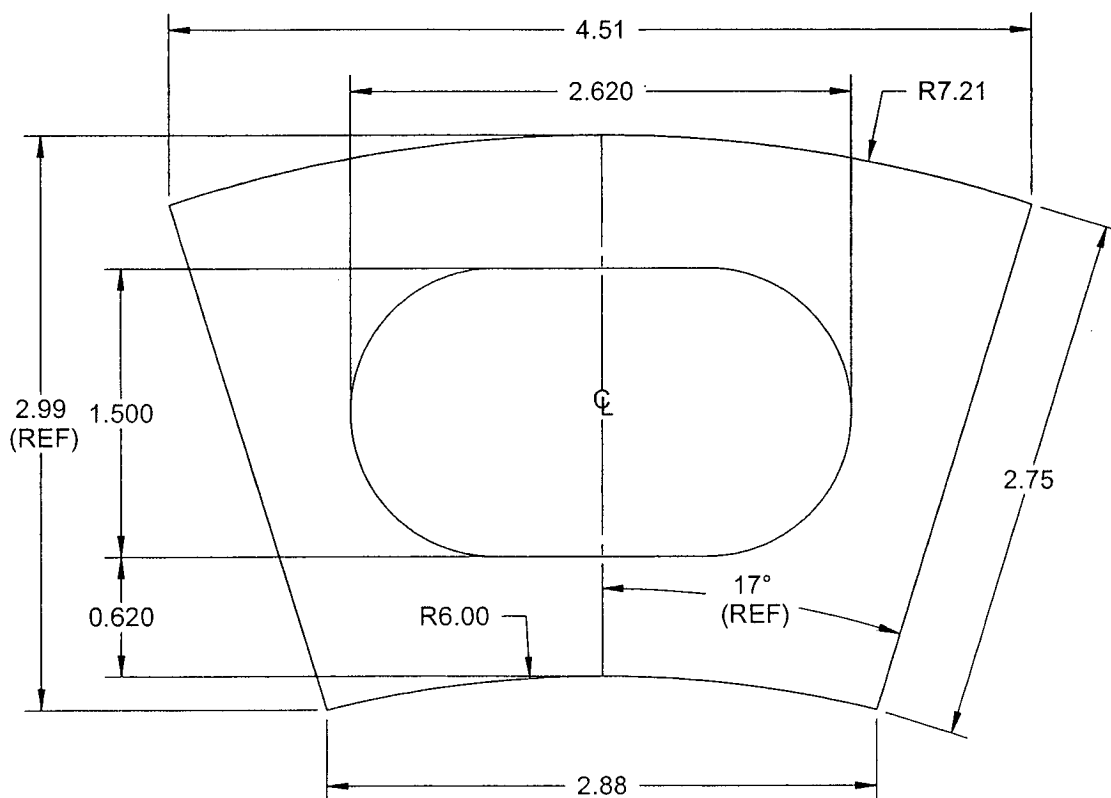
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3472	REV. A SHEET 4 OF 4
DATE 06.01.17		TITLE HEAT OUTLET DEFLECTOR	SCALE 1:1



D3472-5 FLAT DOUBLER

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063" THICK)
PER QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

FAX 1 847 585 2500

CORUS ALUMINIUM

Corus Aluminij - Walzprodukte G. m. b. H.
 Postfach 100331 · D-56033 Koblenz



INSPECTION CERTIFICATE (EN 10204/3.1) / TEST REPORT / APPROVED CERTIFICATE

NO.: 0879231 SERIAL-NO.: PAGE: 2 / 03
 PURCHASER: CORUS ALUMINIUM ROLLED ORDER NO. PURCH.: US-AIRCR. DEPOT-PRO
 PRODUCTS USA-A DIVIS ORDER NO. MAN.: 83415
 SCHAUMBURG, IL 60173 SPEC.: AMS4041+B209+QQ230/5
 CUSTOMER PART NO.:
 ITEM: 01 LOT: 102973 ALLOY/TEMPER: 2024 T3 ALCLAD 1230 PRODUCT: PLA
 QUANTITY: 344 DIMENSIONS: 0.040 x 48.00 x 144.00 INS

Other tests:

Dimensional check:
 Surface control:

OK
 OK

Normative references:

BESTELLNORM/SPECIFICATION/NORME
 AMS 4041P+ASTM B 209-04+AMS-QQ-A-250/5A SEP1998

Bend test:

L-direction

LT-direction OK

ST-direction

18 G. 1
Koblenz



corus

CERTIFICATE (EN 10204/3.1) / TEST REPORT / APPROVED CERTIFICATE
PAGE: 3 / 03

SERIAL-NO.:
CORUS ALUMINIUM ROLLED
PRODUCTS USA-A DIVIS
CHAUMBURG, IL 60173
ORDER NO. PURCH.: US-AIRCR. DEPOT-PRO
ORDER NO. MAN.: 83415
SPEC.:
AMS4041+B209+Q0250/5
CUSTOMER PART NO.:

THAT THE WHOLE OF THE SUPPLIES DETAILED HEREON HAVE BEEN
TESTED AND, UNLESS OTHERWISE STATED ABOVE, CONFORM IN ALL
WITH THE REQUIREMENTS OF THE SPECIFICATION, CONTRACT OR ORDER.

res:

on 25.08.05 SW

G. Mettler
Quality Assurance
Corus Aluminium
Walzprodukte GmbH
Koblenz

MAR-23-2006 04:24 FROM:

TO: 6049464153

Corus Aluminium Walzprodukte G.m.b.H.
Postfach 100331 : D-56033 Koblenz



corus

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 CUSTOMER PART NO.:
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 QUANTITY: 344 DIMENSIONS: 0.040 X 48.00 X 144.00 INS

RESULTS:

Mechanical properties:

Spec. No.	Y.S.	U.T.S.	El.
	KSI	KSI	%
Min. LT:	39,0	59,0	15,0
Max. LT:			
001	40,6	59,6	17,9
002	40,6	59,8	18,7
003	40,8	59,8	17,7
004	40,8	59,6	18,1

Chemical composition: in % , remainder Al

ALLOY:	ALLOY CORE	ALLOY LINER	ALLOY LINER
CAST-NO.	2024	1230 4	1230 4
	5-05-2914	142166-1	142166-1
Si	0,028	0,12	0,12
Fe	0,123	0,26	0,26
Cu	4,326	0,002	0,002
Mn	0,634	0,010	0,010
Mg	1,436	0,003	0,003
Cr	0,001	0,001	0,001
Zn	0,011	0,005	0,005
Ti	0,0278	0,019	0,019
B	0,0006	0,002	0,002
Zr	0,0006		
Pb	0,0016	0,0011	0,0011
Ni	0,0059		